

Date: Wednesday, 2/21/2007 10:31:51 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL REFERENCE DOOR INSTALLATION
Job Number : 30785	
Estimate Number : 12745	
P.O. Number : N/A	Part Number : EA2046922
This Issue : 2/21/2007 S.O. No. : N/A	Drawing Number : D20446901 REV 1
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/21/2007 Type : LARGE FAB ASSY	Drawing Revision : 1
Previous Run : N/A	Material : N/A
Written By : <u>EC</u>	Due Date : 2/28/2007
Checked & Approved By : <u>✓</u>	Qty: <u>42</u> Um: Each
Comment : Est Rev:A New Issue 07-02-21 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M4130NS063	4130 Sheet .063
-----	------------	-----------------



Comment: Qty.: 0.2856 sf(s)/Unit Total : 0.5712 sf(s)

4130 Sheet .063

Batch: M103433M1 07 02 224

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2046901

Dwg Rev: 1Prog Rev: 1M1 07 02 22(4)

2-Deburr if necessary

M1 07 02 22(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

M1 07 02 22(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

EC 07.02.22(4)

Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

M107/02/22 (4)

Date: Wednesday, 2/21/2007 10:31:51 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR INSTALLATION

Job Number: 30785

Part Number: EA2046922

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

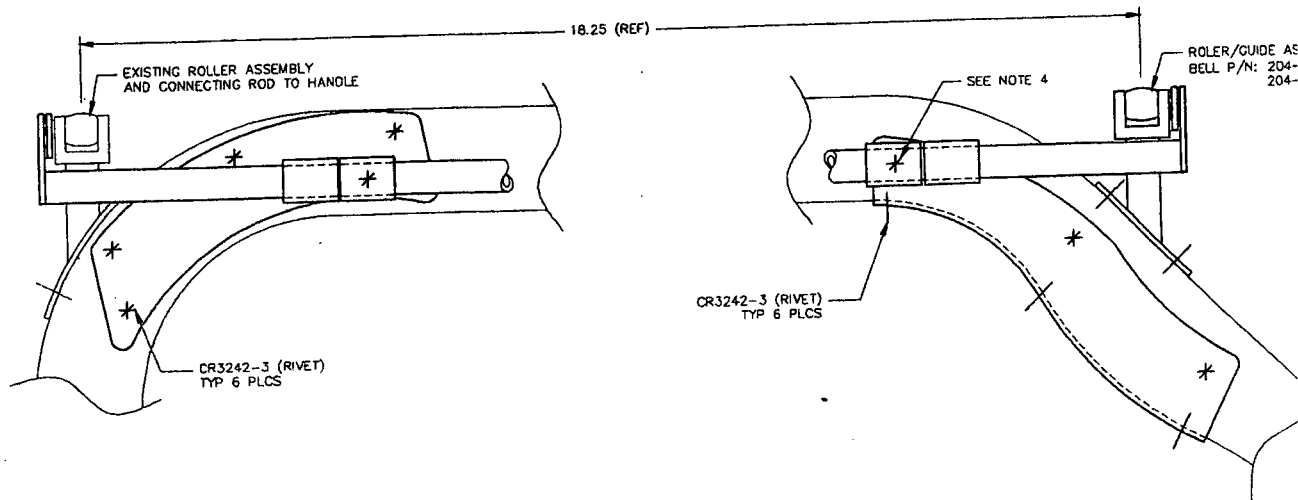
Comment: FINAL INSPECTION/W/O RELEASE

07/02/23

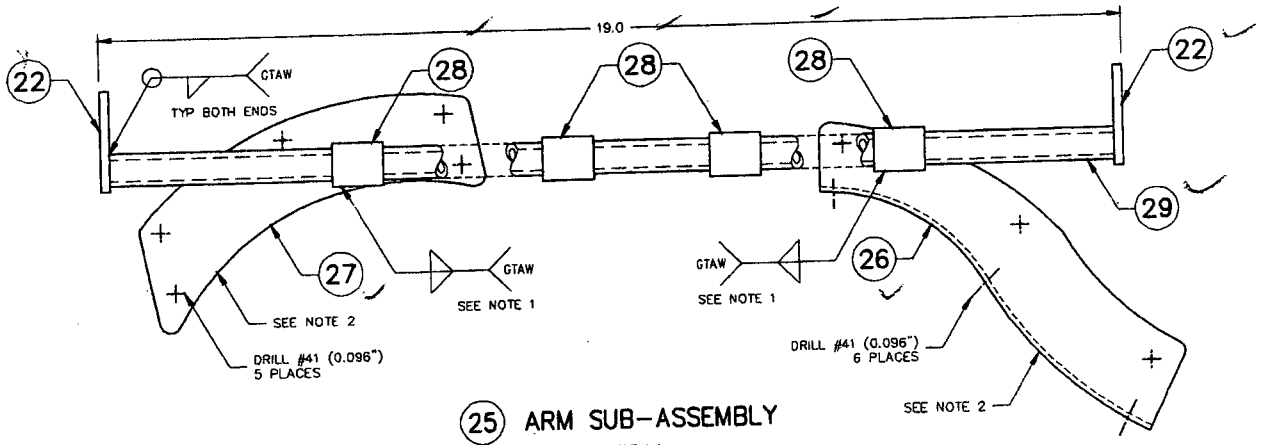
Job Completion



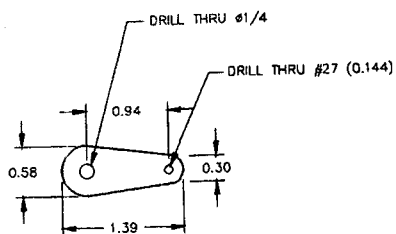
u 07.02.23



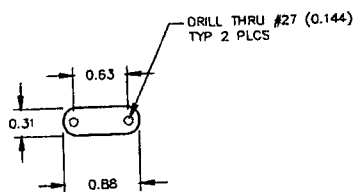
UPPER DOOR LATCH ASSEMBLY
SCALE 1:1



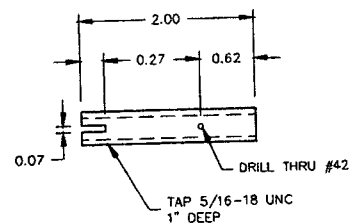
25 ARM SUB-ASSEMBLY
SCALE 1:1



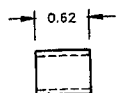
22 LUG
SCALE 1:1



23 LINK
SCALE 1:1



24 ROD
SCALE 1:1

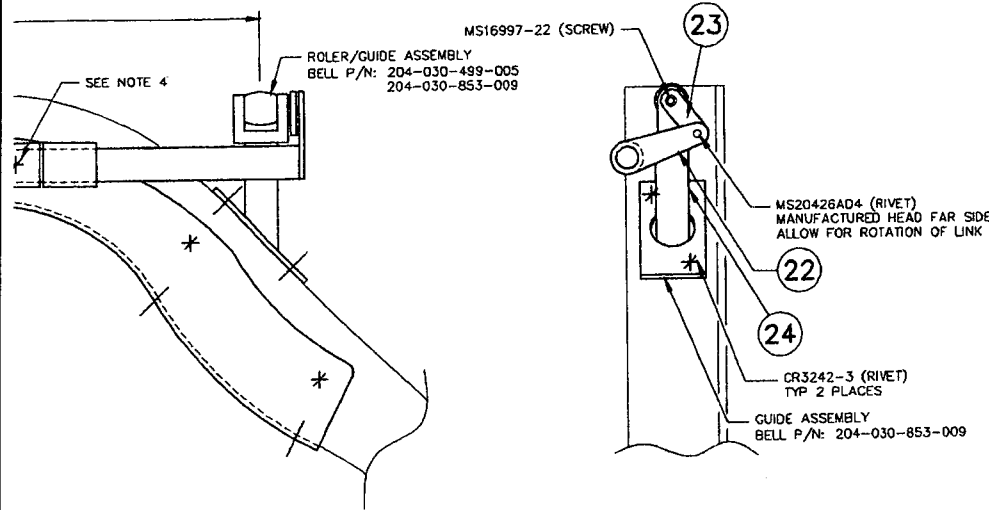


28 ARM GUIDE
SCALE 1:1

NOTICE

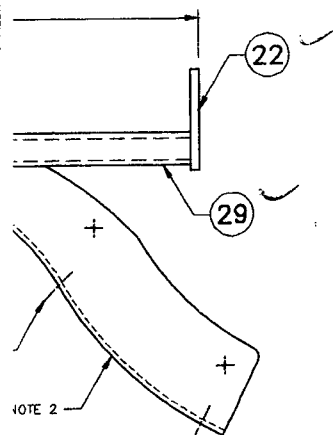
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	DW	15 AUG 21



OR LATCH ASSEMBLY

SCALE 1:1



NOTES FOR SHEET 3.

- WELDING OF 4130 STEEL ALLOY TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS 6437A OR LATER REVISION.
- HEAT AND FORM DOOR PLATES (ITEM 26 & ITEM 27) TO SHAPE OF DOOR JAM. PILOT HOLE LOCATIONS ARE APPROXIMATE. MAINTAIN 2D EDGE DISTANCE.
- THOROUGHLY DEGREASE, PRIME, AND PAINT ALL PIECES AFTER ASSEMBLY.
- OUTER PAIR OF ARM GUIDES (ITEM 28) WELDED TO DOOR PLATES AS SHOWN. INNER PAIR OF ARM GUIDES LEFT LOOSE UNTIL ASSEMBLY WITH DOOR AND THE FASTENED TO ARM WITH CR3242-3 RIVETS AFTER ARM ALIGNMENT.

	1	29	ARM		EA20469-29	4130 STEEL	MIL-T-6736	#3/8 O.D. x 0.093
	4	28	ARM GUIDE		EA20469-28	4130 STEEL	MIL-T-6736	#1/2 O.D. x 0.063
	1	27	DOOR PLATE		EA20469-27	MILD STEEL		0.063" SHEET
	1	26	DOOR PLATE		EA20469-26	MILD STEEL		0.063" SHEET
	1	25	ARM SUB-ASSEMBLY		EA20469-25			
	1	24	ROD		EA20469-24	4130 STEEL	MIL-T-6736	#3/8 O.D. x 0.093
	2	23	LINK		EA20469-23	4130 STEEL	MIL-S-18729	0.063" SHEET
	2	22	LUG		EA20469-22	4130 STEEL	MIL-S-18729	0.063" SHEET
1		21	DOOR COVER PANEL		EA21469-21			
		20	FLIGHT MANUAL SUPPLEMENT 2148, 2148-1		EA21469-20			
		20	FLIGHT MANUAL SUPPLEMENT 212, 412		EA21269-20			
		20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1		EA20569-20			
	1	20	FLIGHT MANUAL SUPPLEMENT 2048		EA20469-20			
	1	19	EAGLE SERVICE INSTRUCTION		EA20469-19			
1		18	DOOR INNER SKIN		EA20469-18			
1		17	ANGLE		EA20469-17			
1		16	ARM REST ASSEMBLY		EA20469-16			
1		15	INSTRUMENT PANEL		EA20469-15			
1		14	WINDOW RETAINER		EA20469-14			
1		13	INSTRUMENT WINDOW		EA20469-13			
1		12	FORWARD RIB		EA20469-12			
1		11	ANGLE		EA20469-11			
1		10	REARWARD RIB		EA20469-10			
1		9	ANGLE		EA20469-09			
1		8	PLACARD - INSTRUMENT PANEL		EA20469-08			
1		7	ANGLE		EA20469-07			
1		6	ALUMINUM STRIP		EA20469-06			
1		5	RUBBER STRIP		EA20469-05			
1		4	DOOR LATCH ASSEMBLY		EA20469-04			
1		3	PLEXIGLASS BUBBLE WINDOW		EA20469-03			
		2	INSTALLATION - DOOR MOUNTED INSTRUMENTS					
		1	INSTALLATION - BUBBLE WINDOW					
2	1	DASH NO.	DESCRIPTION		PART NO.	MATERIAL	MATERIAL SPEC.	STOCK SIZE
QTY.								
</								

LIST OF MATERIALS

DRILL THRU #42

18 UNC

28 ARM GUIDE

SCALE 1:1

BASIC CODE D=DIMPLE DIGIT = # OF SHEETS TO BE DIMPLED C=COUNTERSUNK		DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE DASH NO. FOR LENGTH		APPROVALS DRAWN: E. BURGON CHECKED: STRESS:		DATE 26 AUG 1991		AERO DESIGN LTD. CORPUSCULUS ENGINEERING TRANSPORT CANADA APPROVALS, DAR 230M 1040 McTAVISH ROAD N.E., CALGARY, AL. T2E 7G8	
BASIC CODES: BJ = MS20470AD BB = MS20426AD LZ = NAS1087AD CX = MS204700D		* C INSTALL NEW RIVET + C REMOVE/REPLACE RIVET - C EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		EAGLE COPTERS LTD. 825 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G8 BELL 204, 205, 212 & 214 VERTICAL REFERENCE DOOR INSTALLATION		SCALE AS NOTED SHEET 3 OF 3	
				DWG. SIZE A1		DWG. NO. D2046901		REV.	

DART AEROSPACE LTD	Work Order: 30785
Description: Vertical Reference Door Installation	Part Number: EA20469-22
Inspection Dwg: D20446901, Rev: 1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by:	<i>M M</i>	Audited by:	<i>EE</i>	Prototype Approval:	
Date:	<i>07.02.22</i>	Date:	<i>07.02.26</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	